

Date: Thursday, 05/02/2009 3:47:19 PM
User: Julie Dawson

Process Sheet

SP217

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BASKET (A119) STRUT
Job Number	: 45566		
Estimate Number	: 12436		
P.O. Number	:	Part Number	: D35171
This Issue	: 05/02/2009 S.O. No. :	Drawing Number	: D3517 REV.A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 11 Type : R & D SM/MED FAB	Drawing Revision	: A
Previous Run	: 31802	Material	:
Written By	:	Due Date	: 03/03/2009
Checked & Approved By	: <u>JUD 09.02.06</u>	Qty:	5 Um: Each
Comment	: EST rev. A 05.06.06 preliminary EC est B 07.04.09 revA dwg EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0750X04000	6061-T6 Bar .750 x 4.00
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NOT PULLED



Comment: Qty.: 0.6999 f(s)/Unit Total: 6.9993 f(s)

6061-T6 Bar .75" x 4.0" 09.02.06

Batch: 110912 9-3-13

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3517

Dwg Rev: A

Prog Rev: A

9-3-13

12

2-Open holes to finish size as per Dwg D3517

3-Deburr if necessary

9-3-13

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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9-3-13

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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PB →

Comment: SECOND CHECK

S. 03/16 9-3-13

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

F 09/03/17 9

W/O:

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3517-1 PAR #: N/A Fault Category: Prod / Material NCR: Yes No DQA: D Date: 09/03/16
 Resolution: DIIT-756241 SCRAP Disposition: SCRAP QA: N/C Closed: D Date: 09/03/16

NCR: 45566

WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
7/3/16	#20	two parts found with .750" mat. thickness measuring .870" one part (Qty 1) with cut out in part R.C. operator pull when mat.		Ensure mat'l is ident. filed correctly in stock. & to ALWAYS measure & double check the material being pulled. Face the material down to size on manual milling.	K.A. 09/03/16	S 09/03/16		S 09/03/16
7/3/16	#20	One (Qty 1) part found with 0.257" holes measuring 0.275" ↑↓		Scrap & destroy No replace Qty 2	ml 09/03/16	S 09/03/16		S 09/03/16
9/3/16	#20	2 one parts found with cut out from wake get in Bottom holes R.C. Taper & w. 5 mil. back process		Scrap & destroy. No replace	ml 09/03/16	S 09/03/16		S 09/03/16

NOTE: Date & initial all entries

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Job Number: 45566

Part Number: D35171

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



m 110939



(PD) →

Comment: POWDER COATING

Powder Coat White Gloss (Ref. 4.3.5.1) as per QSI 005 4.3

START TIME:

8:25

OVEN TEMPERATURE:

320°

FINISH TIME:

8:55

umol FL

09/03/18

(X9)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



41



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09/03/18 (4) 04 03 7 6 2 4

8.0

PACKAGING 1

PACKAGING RESOURCE #1



(SK)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 509

9/3/20

SP

9.0

QC21

FINAL INSPECTION/W/O RELEASE



09/03/24

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



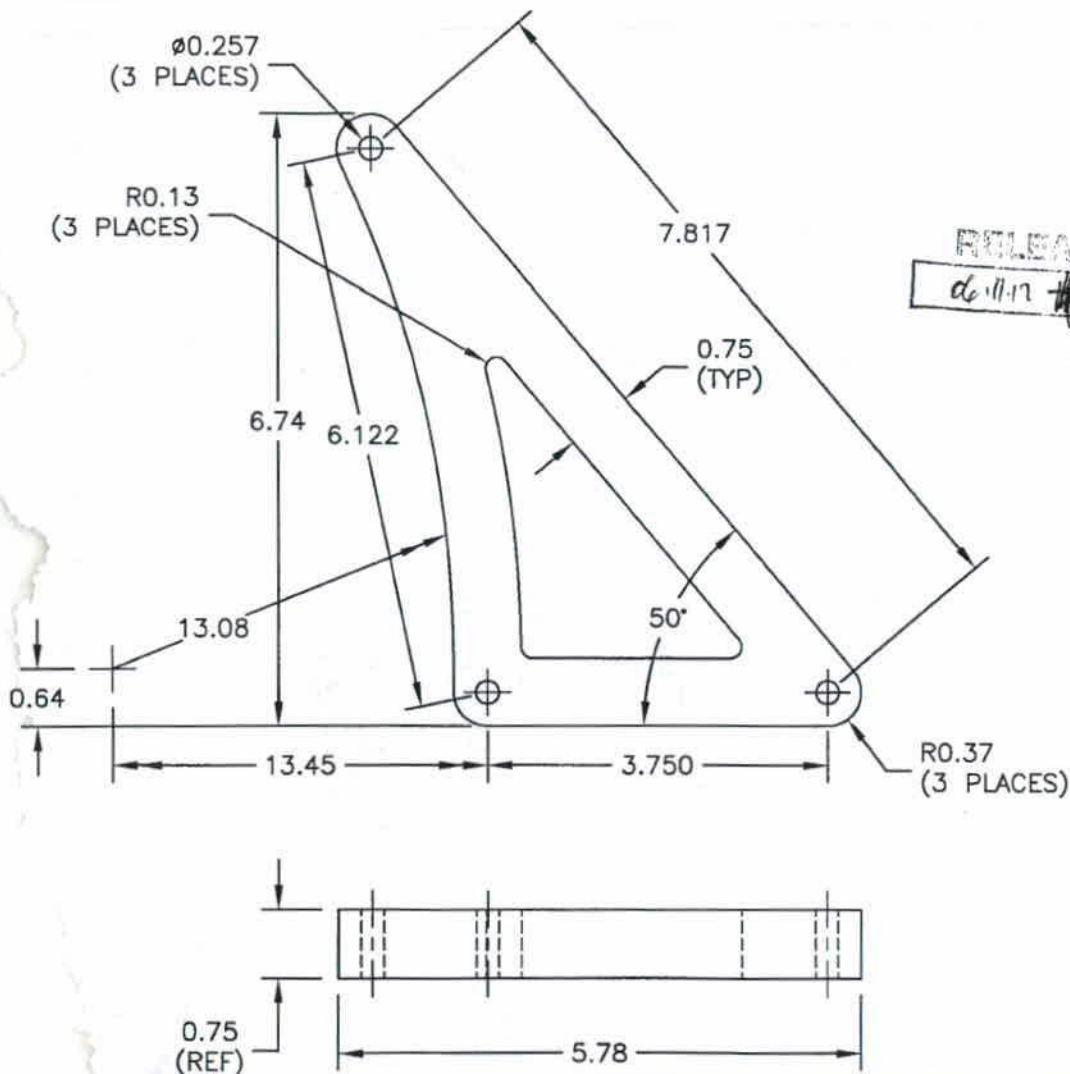
mf
09-03-24

[illegible]

H:\FORMS\Quality Assurance\approved QA\NCRWO RevE

DART

DESIGN B	DRAWN BY B	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3517	REV. A SHEET 1 OF 1
DATE 06.06.07	TITLE BASKET (A119) STRUT		SCALE 1:2
A	06.06.07	NEW ISSUE	

**D3517-1 STRUT**

- 1) MATERIAL: M6061-T6 (OR 6061-T651/T6510/T6511/T6512/T62) ALUMINUM BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF DART MATERIAL SPEC M6061T6B0.750X00.750)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) IDENTIFY WITH DART P/N D3517-1 USING FINE POINT PERMANENT INK MARKER
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES 0.005 TO 0.010 MAX

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WORK ORDER
NO. 45510

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